

Date: Friday, 22/08/2008 10:03:54 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 41590					
Estimate Number	: 10534					
P.O. Number	:			Part Number	: D2574	
This Issue	: 22/08/2008		S.O. No.	: D2574 REV E		
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: MACHINED PARTS		
Previous Run	: 40517			Drawing Revision	: E	
Written By	:			Material	:	
Checked & Approved By	: <u>JUL 08 8.22</u>			Due Date	: 12/09/2008	
Comment	: Est Rev: I As Per RevE 06-01-27 JLM			Qty:	10	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: <u>34874</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>41590</u> Double check by: <u>MJL</u>	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/08/2008 10:03:54 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 41590

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JL 08/09/16

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(10X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M. A 08/09/17

7.0 POWDER COATING POWDER COATING



M108523

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

1:00pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

1:30pm

08-09-17 (X10)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

C-8/8/18 (10)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: stg33

stg33

C-8/8/18 (10)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/09/19 JY

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08/09/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 41590	
Description: Saddle, Aft Inboard				Part Number: D2574	
Inspection Dwg: D2574 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.439	.439	.439	.439		
B	1.745	1.755		1.750	1.749	1.750	1.750		
C	3.495	3.505		3.500	3.499	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	8.000	7.999	8.000		
F	0.490	0.510		.500	.501	.500	.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.501	.499	.501	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.574	.567	.570	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.368	1.371	1.368	1.369		
N	2.495	2.505		2.499	2.499	2.499	2.500		
O	4.119	4.129		4.120	4.122	4.123	4.123		
P	0.115	0.135		.120	.127	.127	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.243	.253	.252	.252		
S	0.115	0.135		.119	.120	.121	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.228	3.230	3.230	3.230		
V	0.230	0.250		.233	.241	.240	.241		
W	0.115	0.135		.118	.131	.124	.127		
X	0.307	0.312		.311	.310	.311	.312		
Y	0.760	0.765		.761	.760	.761	.761		
Z	0.352	0.372		.369	.376	.366	.366		
AA	0.470	0.530		.506	.500	.500	.500		
AB	0.615	0.635		.626	.627	.629	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.247	.248	.252		
AE	1.500	1.520		1.510	1.512	1.512	1.511		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.270	.265	.265	.265		
AH	0.240	0.260		.244	.249	.249	.251		
AI	2.000	2.020		2.002	2.004	2.005	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	Am	Audited by:	JL
Date:	08/09/15	Date:	08/09/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JL

47

DART AEROSPACE LTD	Work Order:	41590
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

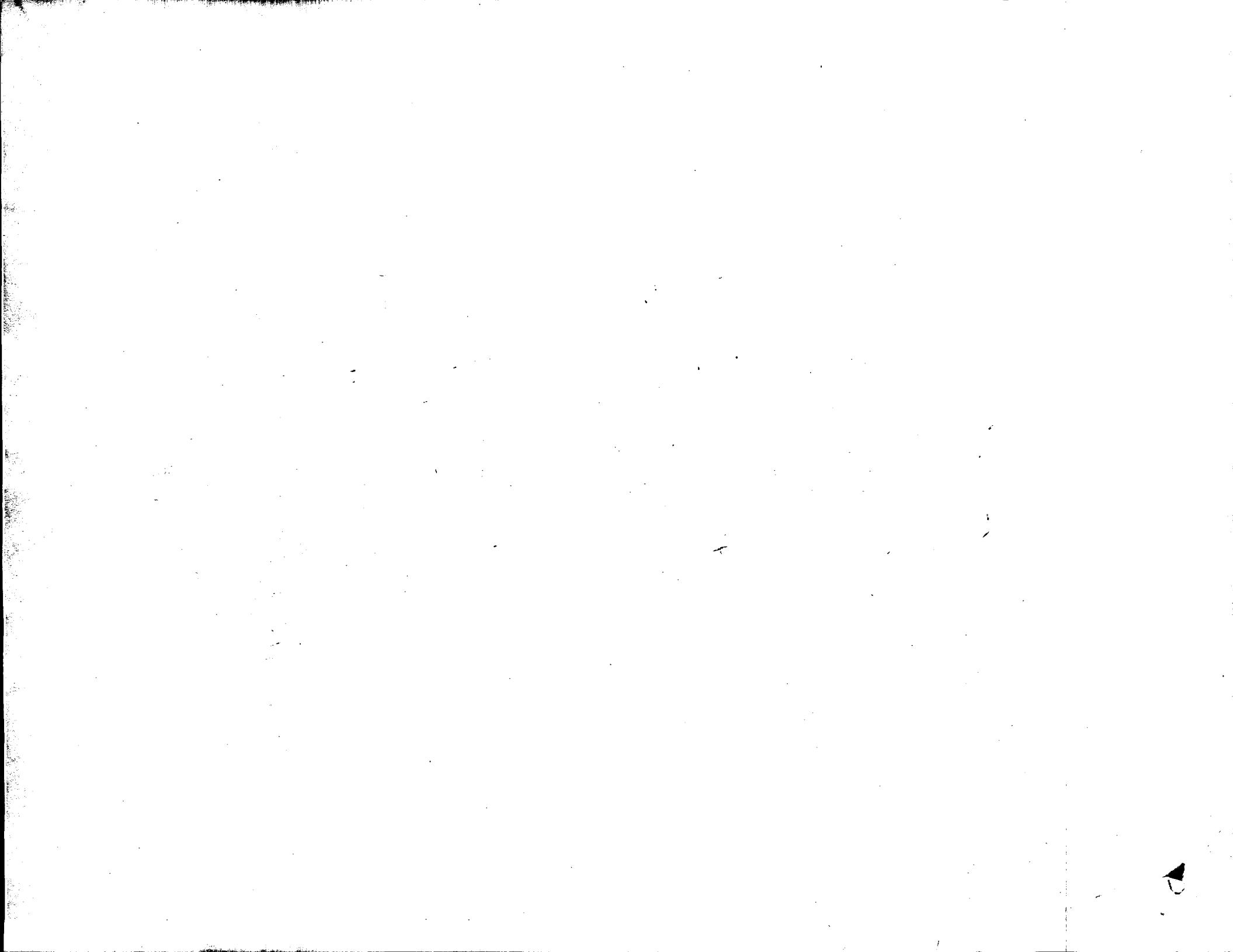
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.438	0.443		.439	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.501	.500	.500	.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.501	.500	.499	.499		
J	1.174	1.184		1.180	1.180	1.179	1.179		
K	0.558	0.578		.561	.567	.568	.566		
L	1.174	1.184		1.178	1.179	1.179	1.179		
M	1.365	1.375		1.368	1.370	1.369	1.369		
N	2.495	2.505		2.499	2.500	2.499	2.499		
O	4.119	4.129		4.121	4.122	4.122	4.123		
P	0.115	0.135		.127	.127	.127	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.252	.252		
S	0.115	0.135		.128	.127	.130	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.242	.242	.241	.241		
W	0.115	0.135		.128	.128	.129	.129		
X	0.307	0.312		.310	.310	.311	.311		
Y	0.760	0.765		.766	.766	.760	.760		
Z	0.352	0.372		.366	.366	.367	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.627	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.254	.246	.249		
AE	1.500	1.520		1.511	1.511	1.511	1.511		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.265	.265	.260	.266		
AH	0.240	0.260		.250	.257	.257	.257		
AI	2.000	2.020		2.003	2.003	2.003	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	<i>Am</i>	/	<i>8/8</i>	Audited by:	<i>J.L.</i>
Date:	<i>08/04/15</i>	/	<i>08/04/16</i>	Date:	<i>08/09/16</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



DART AEROSPACE LTD	Work Order:	41590
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	X9	Z10	3	4	By	Date
A	0.438	0.443		.441	.438				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.000				
F	0.490	0.510		.501	.499				
G	0.257	0.262		.260	.258				
H	0.375	0.380		.377	.376				
I	0.490	0.510		.499	.501				
J	1.174	1.184		1.180	1.180				
K	0.558	0.578		.565	.565				
L	1.174	1.184		1.180	1.180				
M	1.365	1.375		1.371	1.371				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.122	4.122				
P	0.115	0.135		.127	.126				
Q	0.115	0.135		.135	.130				
R	0.240	0.260		.252	.250				
S	0.115	0.135		.126	.127				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.236	3.233				
V	0.230	0.250		.241	.242				
W	0.115	0.135		.121	.121				
X	0.307	0.312		.311	.311				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.360	.360				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.625	.625				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.249	.250				
AE	1.500	1.520		1.516	1.510				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.265	.265				
AH	0.240	0.260		.251	.251				
AI	2.000	2.020		2.003	2.000				
AJ	0.023	0.043		.033	.033				

Accept/Reject

Measured by:	<i>One 186</i>	Audited by:	<i>J.L.</i>
Date:	<i>08/09/16</i>	Date:	<i>08/09/16</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

